



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2807-041
Job Sheet 172537



Part No: D2807-041

Job Qty: 6 ea

Part Name: Prop Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/13/18

Created By: Diane Baker

Type: Stock

Description:

Note: DWG REV E IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	6 pcs		3/12/18	0.00	0.00	Purchasing		AT 18/2/28
110	Packaging	6 pcs		3/12/18	0.00	0.00	Packaging2		AT 18/2/28
120	QC	6 pcs		3/12/18	0.00	0.00	QC6		38 1
130	Small Fab	6 pcs		3/13/18	0.00	0.12	Small Fab-2		9-88 9-88
140	QC	6 pcs		3/13/18	0.00	0.00	QC5		9-88
150	Packaging	6 pcs		3/13/18	0.00	0.00	Packaging3-1		STOL 9-88
160	QC21-SA	6 Ea		3/13/18	0.00	0.00	QC21		9-88

Part Op 100 - Issue P/O: 039070 Order as per Dwg D2807 Possible supplier: Lift Support
Descriptions: Technologies, Saskatoon, Canada P/N 6/15-164/50-115N
110 - Ensure Material Release Note is attached
130 - 1-install D3671-1 as per dwg D2807

MAR 01 2018
FEB 20 2018
DAS
21
9-88
MAR 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3671-1	Placard	6 Ea (1 ea)	100-Purchasing	5038571
6/15-164/50-115N	Gas Spring D2807-041	6 pcs (1 ea)	130-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D3671-1	6	7	0
130-Small Fab	6/15-164/50-115N	6	0	0

Part Specifications

Specifications could not be found.

Container No. 00-1000

Prop Assembly

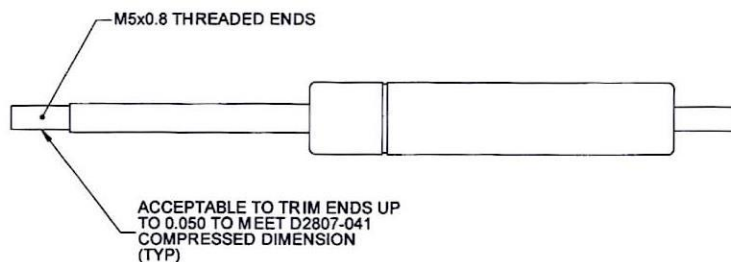
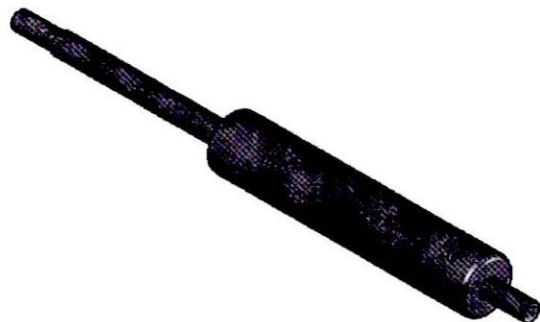
Prop Assembly

PART NO: D2807 – 041
Serial No/Batch: S046602
Revision:
Operation: Packaging
Change No:

M
J

Packaging

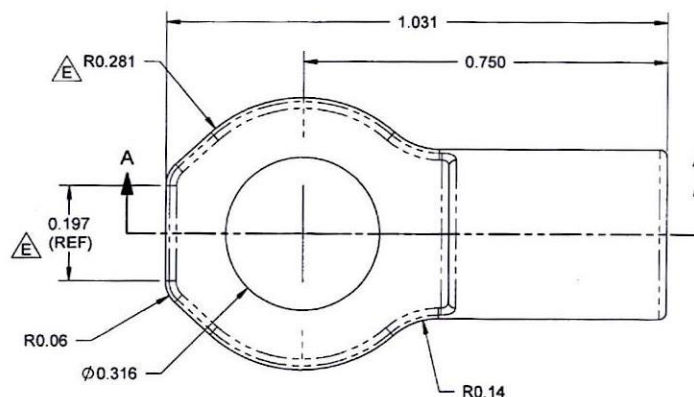
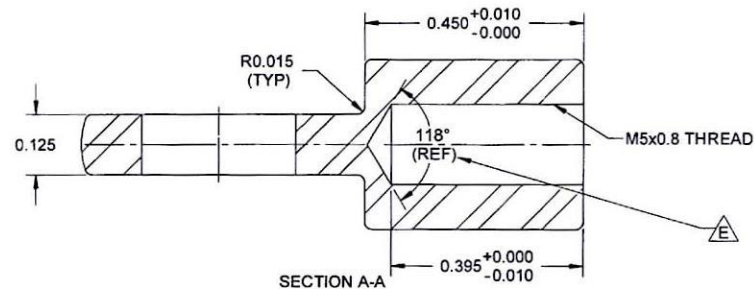
Mfg Date: 02/28/18
Job No: 172537



D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

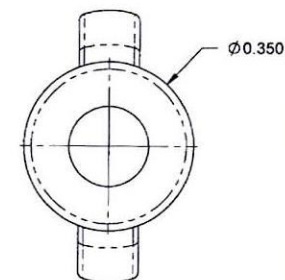
- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS



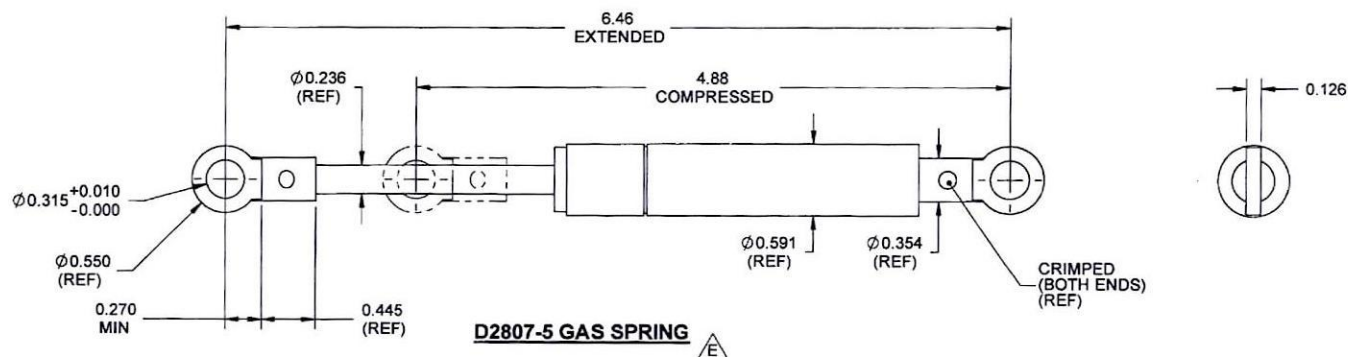
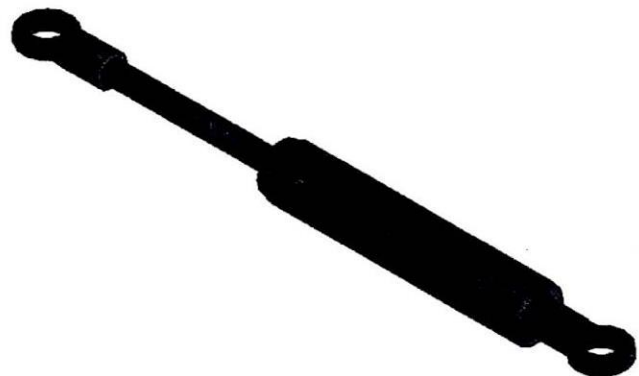
D2807-3 LUG

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.		D2807	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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D2807-5 GAS SPRING

D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS, ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.	JE	D2807	SHEET 3 OF 3
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SPECIFICATION CONTROL DRAWING

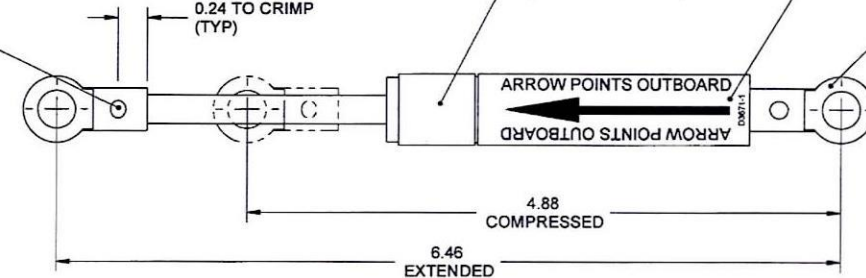
(8)
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH Ø0.375 TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG

(8)
0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(8)
(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

RELEASED
06-11-17

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.169 LBS
 - 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

E	ADD D2807-5 GAS SPRING; D2807-11-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2807 TITLE GAS SPRING REV. E SHEET 1 OF 3 SCALE NTS COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	JE		
CHECKED	JE		
MFG. APPR.	JE		
APPROVED	JE		
DE APPR.	JE		
DATE	07.12.28		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER PO039070

Supplier: LST001-VC
LS Technologies Inc.
1634 Saskatchewan Ave.
Saskatoon
SK
S7K 1P6 Canada
Phone: 306 683 5000
Fax: 306 683 6403

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039070
PO Date: 2/20/18
Due Date: 3/13/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:
Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
FEB 21 2018

copy

Items									
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Extended Price
1	6/15-164/50-115N			Gas Spring D2807-041 As per Dwg D2807 Rev. E	Firmed	3/13/18	6 pcs	0 pcs <i>6x</i>	\$306.72
Line Item Note job# 172537									
2	B6-190-475-070N			Door Prop D3552-23 As per Dwg D3552 Rev. L	Firmed	3/13/18	6 pcs	0 pcs <i>6x</i>	\$195.00
Line Item Note job# 172539									
3	B8-154-387-156NX			Gas Spring D3552-17 As per Dwg D3552 Rev. L	Firmed	3/13/18	6 pcs	0 pcs <i>6x</i>	\$159.00
Line Item Note job# 172540									
4	B8-220-530-070N			Carbon Steel Gas Spring D3552-7 As per Deg D3552 Rev. L	Firmed	3/13/18	10 pcs	0 pcs <i>10x</i>	\$294.80
Line Item Note job# 172543									
5	SSA4/6-122-315-310N			Gas Spring D3969-1 As Per Dwg D3969 Rev. D	Firmed	3/13/18	6 pcs	0 pcs <i>6x</i>	\$311.10
Line Item Note job# 172547									Grand Total: \$1,266.62

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION

[Handwritten signature]



LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

Feb 22, 2018

This is to certify that the parts listed below meets specifications as required by your order.

6 Units: D2807-041 #172537 Stainless Gas Spring

6 Units : D3552-23 #172539 Gas Spring

6 Units : D3552-17 #172540 Gas Spring

10 Units : D3552-7 #172543 Gas Spring

6 Units: D3969-1 #172547 Stainless Gas Spring

Country of Manufacture: Canada
Date of Manufacture : Feb 2018
This product is ROHS compliant.

Purchase Order # 039070
Invoice # 17985

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President